

Work Order ID 85025

Thursday, May 31, 2012 12:48:01 PM

Push
85025

Page 1

Item ID: K10019

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Assembly

Stop

NS2

Start Date: 5/31/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/4/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MK*

Date: 12-05-31 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

100

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

{ Assemble D2195-1/-2/-3 using MS20470AD4-14 rivet
Assemble D2196-1/-2/-3 using MS20470AD4-14 rivet
Assemble D2197-1/-2/-3 using MS20470AD4-14 rivet

IX D2195
D2196
D2197

12/06/12

110

110

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

(1) D2195
D2196
D2197

12/06/12

120

120

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****Powder Coat D2195, D2196, D2197*****

1=30
320°F
2:40

IX

12/06/12

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: K10019

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 5/31/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/4/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

1 0 12-6-5

140

Packaging

0.00

140

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K10019

Location: _____

PPP Rev: _____

12/6/58

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/78

mf
12-06-04

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 85025

Parent Item: K10019

Parent Item Name: Bracket Assembly

Start Date: 5/31/2012

Required Date: 6/4/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: A 08.07.24 new issue EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2195-1 Bracket		Manufactured	No			100	Each	3.0000	1	1		5/12/06/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		1		B85033					
				40928		1							
				Mezz		2							
				40763		2							
D2195-2 Bracket		Manufactured	No			100	Each	2.0000	1	1		5/12/06/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2		B85034					
				40761		2							
D2195-3 Spacer		Manufactured	No			100	Each	3.0000	1	1		5/12/06/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		1							
				40762		1							
				ST005		2							
				60930		2							
D2196-1 Bracket		Manufactured	No			100	Each	2.0000	1	1		5/12/06/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2							
				40760		2							
D2196-2 Bracket		Manufactured	No			100	Each	2.0000	1	1		5/12/06/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2							
				40764		2							

W/O:		WORK ORDER CHANGES					
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Parent Item: K10019

Parent Item Name: Bracket Assembly

Start Date: 5/31/2012

Required Date: 6/4/2012

Start Qty: 1.00

Required Qty: 1.00

D2196-3
Spacer

Manufactured No

100 Each 2.0000

1

1

Location

Loc Qty

Loc Code

ST006

2

60056

1

62771

1

D2197-1
Bracket

Manufactured No

100 Each 8.0000

1

1

Location

Loc Qty

Loc Code

Mezz

8

19154

4

40766

3

62385

1

D2197-2
Bracket

Manufactured No

100 Each 10.0000

1

1

Location

Loc Qty

Loc Code

Mezz

10

19154

4

40767

3

62386

3

D2197-3
Spacer

Manufactured No

100 Each 27.0000

1

1

Location

Loc Qty

Loc Code

Mezz

27

19154

25

40833

1

60036

1

D2198-1
Bracket

Manufactured No

140 Each 6.0000

6

6

Location

Loc Qty

Loc Code

ST006

6

80007

6

5/12/06/04
85037

SP 6 6 B59946
B60856 30

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Shop Packet Print

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10019
Parent Item Name: Bracket Assembly

Start Date: 5/31/2012

Required Date: 6/4/2012

Start Qty: 1.00

Required Qty: 1.00

D3191-1
Backer Plate
Manufactured No 140 Each 7.0000

2 2

Location Loc Qty Loc Code

Mezz 3

40983 3

ST032 4

60867 4

D3191-3
Backer Plate
Manufactured No 140 Each 9.0000

2 3 3

Location Loc Qty Loc Code

Mezz 3

40984 3

ST032 6

57747 6

D3191-5
Backer Plate
Manufactured No 140 Each 4.0000

3 1 1

Location Loc Qty Loc Code

ST032 4

62772 4

MS20470AD4-14
Rivet
Purchased No 100 Each 208.0000

16 16

Location Loc Qty Loc Code

ST320 208

1046 158

109059 50

10

6/5/12

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